

Work Order ID 111681

March-03-15 1:15:48 PM

111681

Page 1

Item ID: D206-547-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Console High Slope

Stop ***NS2***

Start Date: 1/20/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/24/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-547	Rev F								

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-42-Debur

4 FF MAR 2 6 2015

110

0.00

110

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Grind weld relief chamfer as per Dwg D206-5472-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

4 FF MAR 2 6 2015

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

(4) DAG
38
9-89
MAR 2 6 2015

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Cust Item ID:

Required Date: 1/24/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Large Fab	0.00							
130									
Large Fab	Memo	0.00							
Large Fab	1-Tack weld as per Dwg D206-547A/R Batch: <u>122377</u>	AL ROD							
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									DAS 38 9-89 APR 01 2015
150	QC10- Inspect visual per QSI004- ground welds	0.00							
150									
QC	Memo	0.00							
Quality Control									DAS 38 9-89 APR 01 2015

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Console High Slope

Stop ***NS2***

Start Date: 1/20/14 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 1/24/14 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							DAS 38 9-89
190						(4)			
QC	Memo	0.00							
Quality Control									APR 14 2015
200	Identify as per dwg & Stock Location: _____	0.00							DAS 27 9-89
200									
Packaging	Memo	0.00							
Packaging									APR 16 2015
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									MLJ 15 04-16 MF 15-4-16

Picklist Print

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Work Order ID: 111681

111681

Parent Item: D206-547-043

D206-547-043

Parent Item Name: Console High Slope

Start Date: 1/20/14

Required Date: 1/24/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:I06-01-05 Removed Packing Kit JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2024		Manufactured	No			110	f	905.0000	3.42	15			
D2024									**				
Extrusion (\$per sq ft)													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT051				905					
				1				905		15			
D2602-1		Manufactured	No			110	Each	6.0000	1	4			
D2602-1									**				
Console Side, 206 Console													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST482				6					
				117859				4		2			
				125300				2		2			
D2602-2		Manufactured	No			110	Each	11.0000	1	4			
D2602-2									**				
Console Side, 206 Console													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST482				11					
				102224				1		1			
				104427				5		3			
				117886				5					
D2606		Manufactured	No			110	Each	11.0000	1	4			
D2606									**				
Console Bracket, 206/407 Console													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST008A				11					
				104506				3		3			
				119393				8		1			

Picklist Print

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Work Order ID: 111681

Parent Item: D206-547-043

Parent Item Name: Console High Slope

111681

D206-547-043

Start Date: 1/20/14

Required Date: 1/24/14

Start Qty: 4.00

Required Qty: 4.00

D2607

Manufactured No

110

Each

16.0000

1

4

D2607

Bracket, 206 Console

**

FF

MAR 26 2015

Location

Loc Qty

Loc Code

ST008A

11

104187

10

104190

1

ST025A

5

98900

5

MS20470AD3-3

Purchased

No

110

Each

6,770.000

8

32

MS20470AD3-3

RIVET, UNIVERSAL HEAD

**

FF

APR 07 2015

Location

Loc Qty

Loc Code

GA

1050

1065

1050

ST311

5720

16941

5720

MS20470AD3-4

Purchased

No

100

Each

2,415.000

20

80

MS20470AD3-4

Rivet, Universal Head

**

FF

MAR 26 2015

Location

Loc Qty

Loc Code

GA

1170

111477

1170

ST311

1245

111477

1245

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Shop Packet Print

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DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED KE	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY	SCALE NTS
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.B.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043,-045,-047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

RELEASED
99.03.05 RE

-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET

20111108

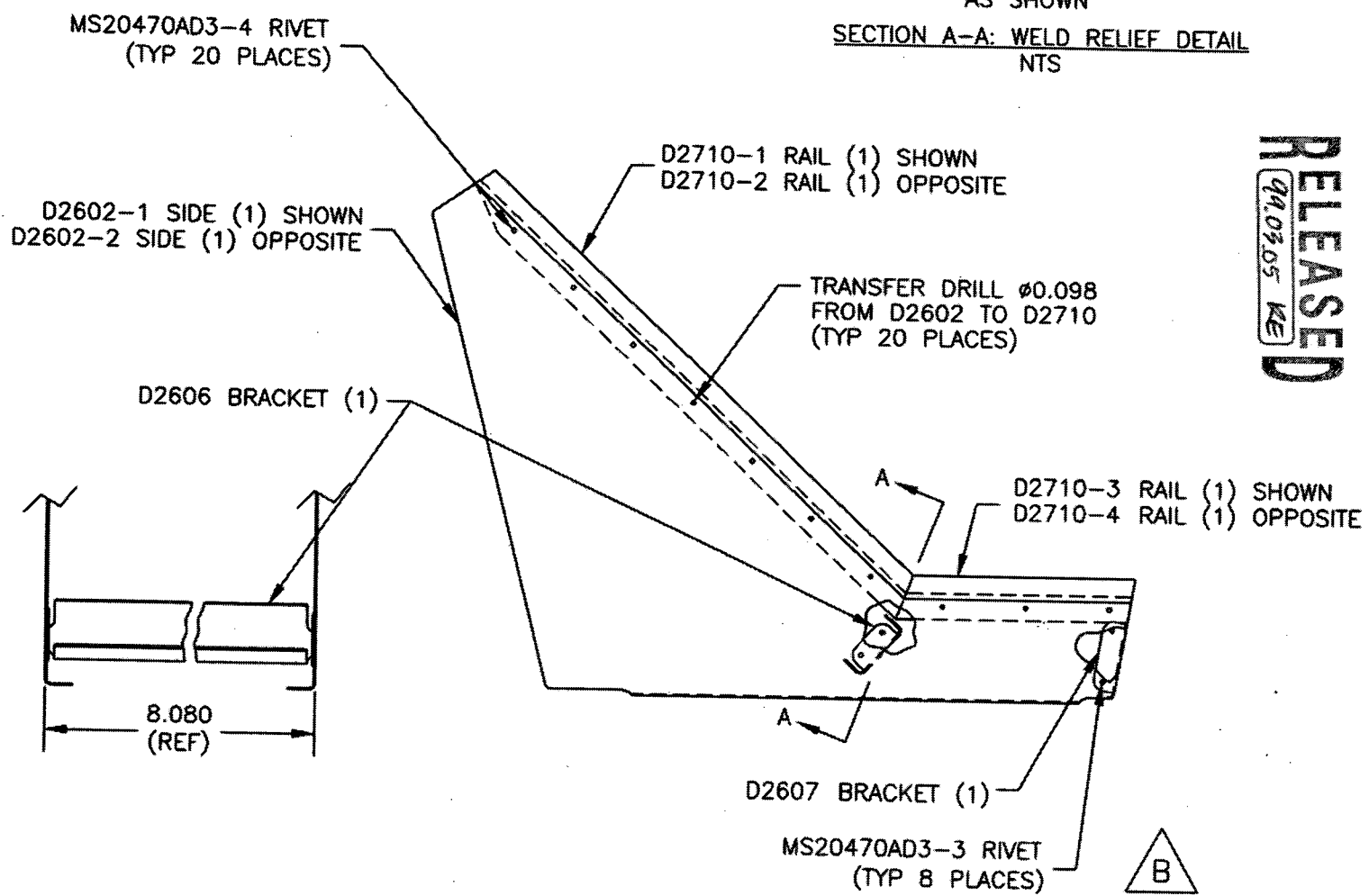
DART

RELEASED
99.02.05 KE



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-043 (206 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CP	APPROVED	KE	
DATE	99.02.11	DRAWING NO.	D206-547	REV. F
		TITLE	CONSOLE ASSEMBLY	SHEET 3 OF 5
				SCALE 1:4

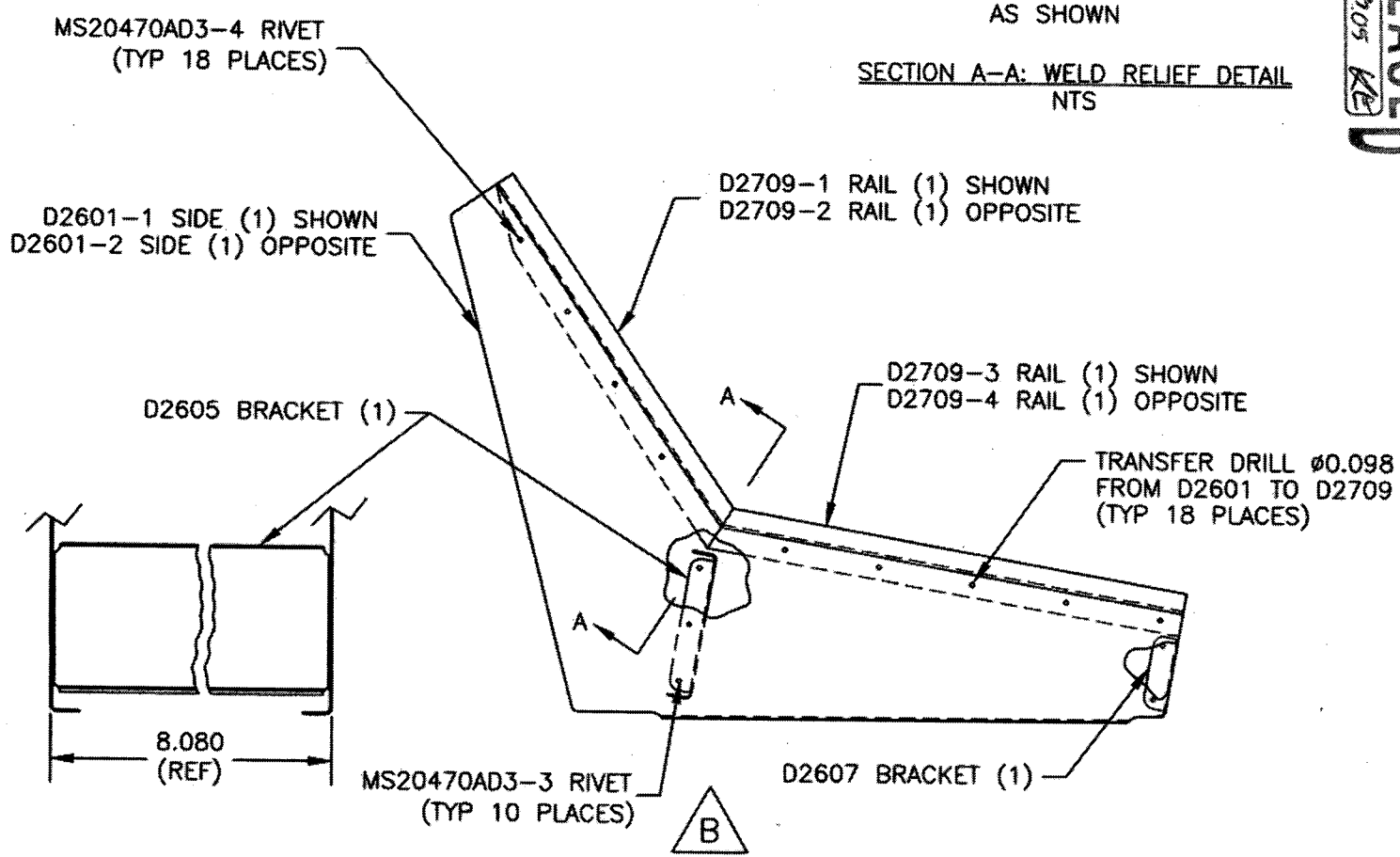
DART

RELEASED
M0305 KE



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-041 (206 LOW SLOPE CONSOLE)

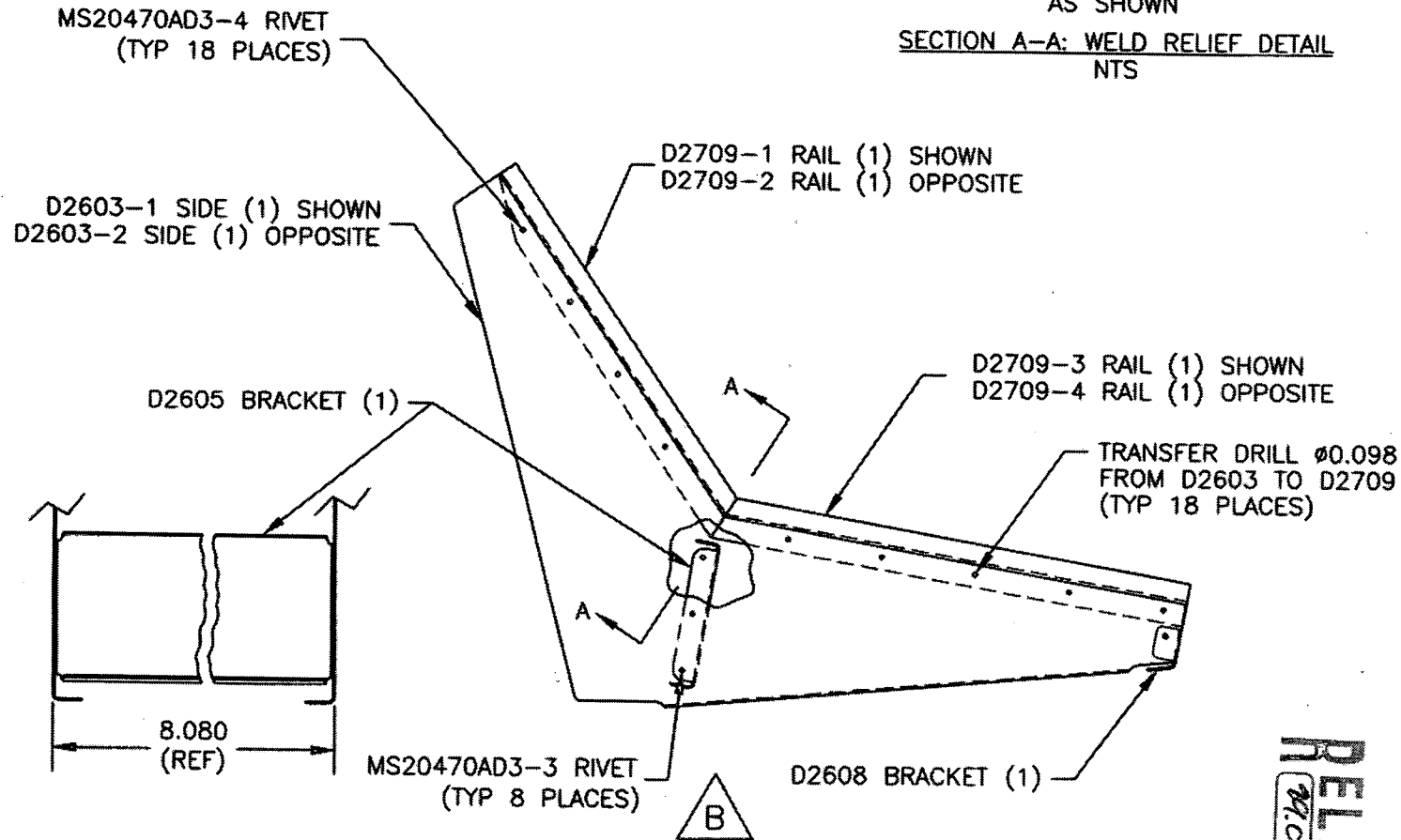
FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED	JP	APPROVED	KE	HAWKESBURY, ONTARIO, CANADA
DATE	99.02.11	DRAWING NO.	D206-547	REV. F
		TITLE	CONSOLE ASSEMBLY	SHEET 2 OF 5
		SCALE	1:4	



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
M.0305 DE

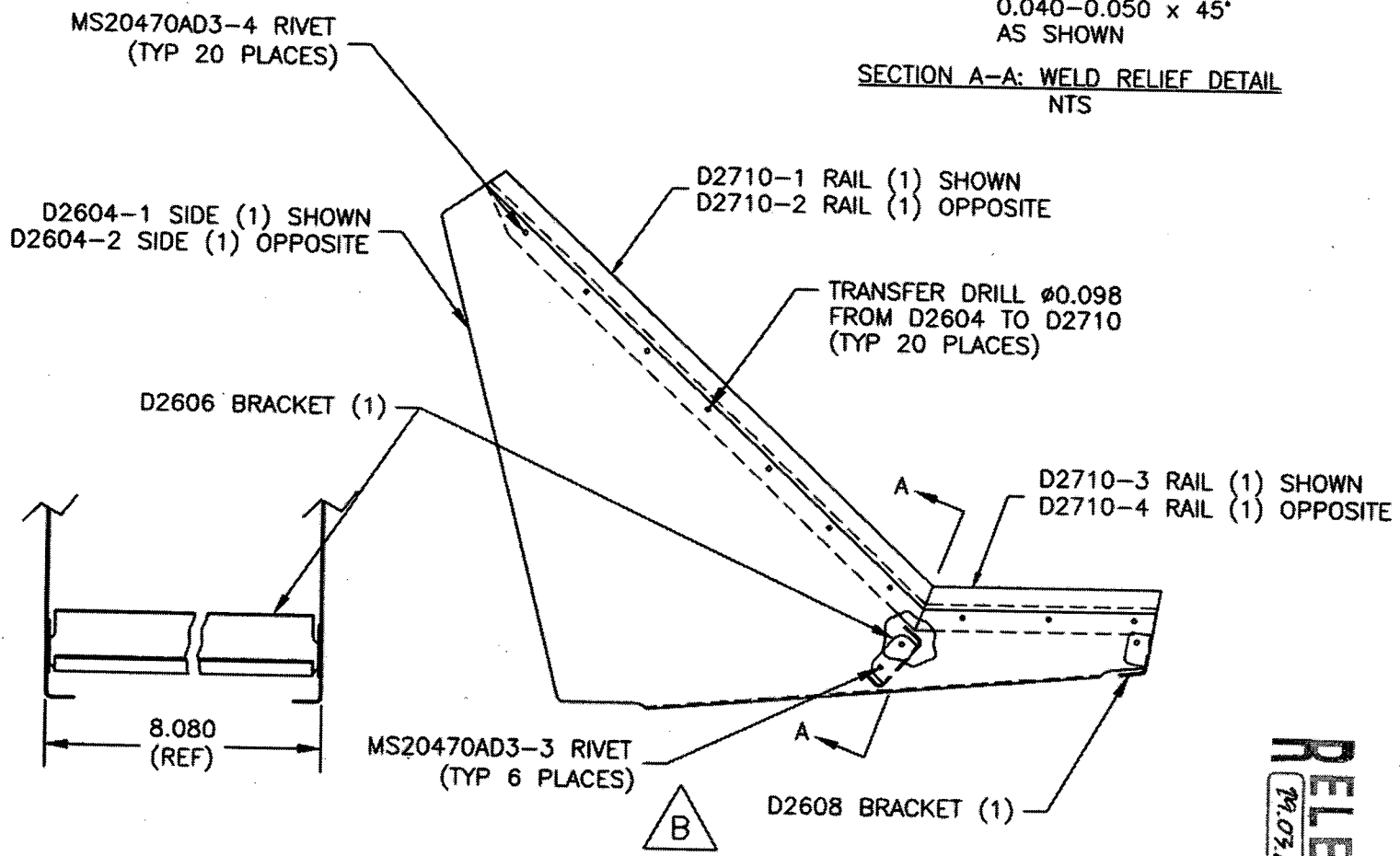
DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAMMERSBURT, ONTARIO, CANADA
CHECKED JP	APPROVED KE	DRAWING NO. D206-547
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	REV. F SHEET 4 OF 5
	SCALE 1:4	

DART



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
190305 KE

DESIGN	BW	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED	UP	APPROVED	KE	HAWKSBURY, ONTARIO, CANADA
DATE	99.02.11	TITLE	D206-547	REV. F
		CONSOLE ASSEMBLY		SHEET 5 OF 5
				SCALE 1:4